

Work Order ID 54829

December 22, 2009 2:16:41 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *CZ* Date: *09/12/22* Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

Sub 1, 2

Hg for MF 10/01/20

110 0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *14005* Description: D2445 Baggage Door Supplier: Delastek Ship to Delastek (1) D0588-041 label Certification of Conformity and process sheet from Delastek is required.

CZ 09/12/22 ①

120 0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

Pd 12/4/10 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

▲ NOTE: Date & initial all entries

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December 22, 2009 2:16:41 PM



Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445. Audit process sheet.

⇒ 8.01.01/20

Pip 7
1/25

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

8.10.01.20

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



⇒ 8.01.01/20

(H)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/20	#130	Found at inspection many multiple Dimples from the molds at Delastik AND Finish is very "cloudy"		Scuff with 320 grit sand paper - Re paint with imron per ASTM ASTM 2005 in _____				 10/1/20
		n/a		→ inform Delastik of issue to prevent from happen again				 10/1/20

NOTE: Date & initial all entries

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December 22, 2009 2:16:41 PM



Page 3

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC4- 100% Inspect kits for completeness

0.00

⇒ Sclurbi



QC

Memo

0.00



Pho →

Quality Control

170

Identify as per dwg & Stock Location: 43

0.00

Revo



Packaging

Memo

0.00

10-1-21 Def

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/01/21 JF

Quality Control

MF 10-1-21

Dart Aerospace Ltd

W/O: 54829		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/1/20	#160	Parts missing from from w/o to IFA ADD miss'g Parts: D262-17 B# <u>50666</u> +1 S (S-Less) 1 square ft of 902 G142 cloth #111/66 S	SP 10-1-21			W	S 10/1/20	
		→ up Onite Bom + up ADD ADD Sequence #'s to make entry for Pickin Kit's For Assembly + Packing ADD copy's for Ref. PERM. CHANGE	AA	10/01/21		W	S 10/1/20	

Part No: D350-588-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:40 PM

Page 1

Work Order ID: 54829

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R7 Screw		Purchased	No				Each	136.0000	2.0000		10-1-20	sf

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	136	
104394	3	
113064	100	
113096	33	

AN526C632R8



Screw

Purchased

No

Each

312.0000

8.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	312	
2405	312	

10-1-20 sf

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

December 22, 2009 2:16:40 PM

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Required Date: 1/15/10

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN526C832R9

For Jan

Purchased

No

Each

229.0000

8.0000



M113595 10-1-20 af

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

229

107376

51

108377

5

108928

14

110372

8

110915

1

111916

1

112492

149

December 22, 2009 2:16:40 PM

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Page 2

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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Page 3

December 22, 2009 2:16:40 PM

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10

For Jan

Purchased

No

Each

1,486.000

2.0000



M113064

Washer

NAS1149 D03632

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

• ST

1486

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

174

112369

22

113149

1000

Q51 0.17 sf

December 22, 2009 2:16:40 PM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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December 22, 2009 2:16:40 PM

Page 4

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Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No				Each	1,486.000	2.0000			



Washer

1AS114950363 2

QSI 017 sf



M113064 10-1-20 sf

(12)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1486

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

174

112369

22

113149

1000

December 22, 2009 2:16:40 PM

Shop Packet Print

Page 4

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD8  Washer		Purchased	No				Each	1,217.000	8.0000			
--	--	-----------	----	--	--	--	------	-----------	--------	--	--	--

10-1-20 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1217

107091

9

108335

11

110382

48

110917

3

111578

60

112314

366

112385

720

8

AN960JD8 ~~For Jan~~

Washer

Purchased No

Each 1,217.000 16.0000

10-1-20 16 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1217

107091

9

108335

11

110382

48

110917

3

111578

60

112314

366

112385

720

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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December 22, 2009 2:16:40 PM

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Required Date: 1/15/10

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2143		Manufactured	No				Each	29.0000	1.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Hinge Bracket



10-1-2009

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

29

37739

29

D2144		Manufactured	No				Each	14.0000	1.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Hinge Bracket



10-1-20 50

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

14

41174

14

D2150		Manufactured	No				Each	16.0000	2.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Packer Doubler, Hinge



B55016 10-1-2009

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

16

45813

16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 7

December 22, 2009 2:16:40 PM

Work Order ID: 54829

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2151		Manufactured	No				Each	60.0000	2.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Packer Doubler, Hinge

Warehouse
Location

Main Warehouse

ST

51407

Loc Qty

60

60

Loc Code

Each

34.0000

1.0000



10-1-2009

D2153



Door Prop

Manufactured No

Warehouse
Location

Main Warehouse

ST

48373

Loc Qty

34

34

Loc Code

Each

29.0000

1.0000



10-1-20 50

D2154



Stud Bracket

Manufactured No

Warehouse
Location

Main Warehouse

ST

44890

45814

Loc Qty

29

19

10

Loc Code

10-1-20 50

December 22, 2009 2:16:40 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2237		Manufactured	No				Each	64.0000	2.0000			
-------	--	--------------	----	--	--	--	------	---------	--------	--	--	--



Striker Plate

10-1-2009

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 9

46162 9

Main Warehouse

ST022 55

52327 55

f 170.7040 7.2500

D2461		Manufactured	No				f	170.7040	7.2500			
-------	--	--------------	----	--	--	--	---	----------	--------	--	--	--



Neoprene "D" Seal

1 @ 87" Long
L7 mead
8/10/10/20

2
10-1-2009

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 170.7039842

34304 14.234

39782 156.469984

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 9

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D2463 Seal	@ 87" long	Manufactured	No				f	577.1626	7.2500			
											10-1-20	SL

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	75.3752	
31350	1.8278	
34305	18.25	
41121	3.75	
43841	51.5474	

Main Warehouse

ST404	501.7873684	
50075	501.787368	

D2585

Manufactured No



Mounting Channel

Each 90.0000 2.0000



10-1-20 SL

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	64	
45888	4	
53798	60	

Main Warehouse

ST37	26	
51526	26	

2

December 22, 2009 2:16:40 PM

Shop Packet Print

Page 9

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D2586 Door Latch		Manufactured	No				Each	89.0000	2.0000		10-1-20	sl

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

• ST

89

45554

1

47183

2

50213

86

D2589



Keys, Key Chain, 350 Hinge

Manufactured No

Each

56.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

HONG KONG

ST

1

46840

15

46846

1

50378

40

D2621



Latch Plate, 350 Spacepod

Manufactured No

Each

66.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

66

46842

66

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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D2857-1  Hinge Bracket		Manufactured	No				Each	29.0000	1.0000 		10-1-20	P

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

41166

7

45788

4

50235

6

53464

12

D2857-2

Manufactured No



Hinge Bracket

Each

25.0000

1.0000


10-1-20

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

25

45797

13

53465

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:40 PM

Work Order ID: 54829



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2858-1		Manufactured	No				Each	27.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>Hinge Bracket</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>43364</p> <p>45798</p> </div> <div> <p>Loc Qty</p> <p>27</p> <p>3</p> <p>24</p> <p>Each</p> <p>19.0000</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> <p></p> <p></p> </div> </div>												

10-1-20

SP

D2858-2		Manufactured	No				Each	19.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>Hinge Bracket</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>41439</p> <p>45799</p> </div> <div> <p>Loc Qty</p> <p>19</p> <p>4</p> <p>15</p> <p>Each</p> <p>7,765.000</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> <p></p> <p></p> </div> </div>												

10-1-20

SP

MS20426AD3-4		Purchased	No				Each	7,765.000	12.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>RIVET</p> </div> <div> <p>Warehouse Location</p> <p>Main Warehouse</p> <p>ST</p> <p>104374</p> <p>110398</p> </div> <div> <p>Loc Qty</p> <p>7765</p> <p>3765</p> <p>4000</p> </div> <div> <p>Loc Code</p> <p></p> <p></p> <p></p> </div> </div>												

10-1-20

SP (R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:40 PM

Work Order ID: 54829



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-5

Purchased

No

Each

2,485.000

18.0000



10-1-20

sf

Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2485

109031

6

111916

2479

MS21042L08

Purchased

No

Each

453.0000

8.0000



M113595

10-1-20

sf

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

453

110002

24

111889

30

112243

43

112492

24

112612

1

112794

31

113149

100

113226

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:40 PM

Work Order ID: 54829



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No				Each	453.0000	10.0000			
Nut												

11113595 10812050

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	453	
110002	24	
111889	30	
112243	43	
112492	24	
112612	1	
112794	31	
113149	100	
113226	200	

MS21042L3 Purchased No



Nut

Each 2,372.000 4.0000



10-1-20 1050

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 2:16:40 PM

Work Order ID: 54829

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly


Comments:

Start Date: 12/22/09

Required Date: 1/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No				Each	2,372.000	2.0000		10-1-20 sl	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2372	
110844	35	
111274	27	
111668	64	
112314	1746	
112385	500	

MS27039-08-11/

Purchased

No

Each

76.0000 / 2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
111977	76	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 16

December 22, 2009 2:16:40 PM

Work Order ID: 54829



Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 12/22/09

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No				Each	163.0000	2.0000			
											10-1-2009	
Screw												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

163

106903

3

108169

4

109321

4

111916

52

112794

100

2

D24457

Purchased

B54829 10-1-20 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

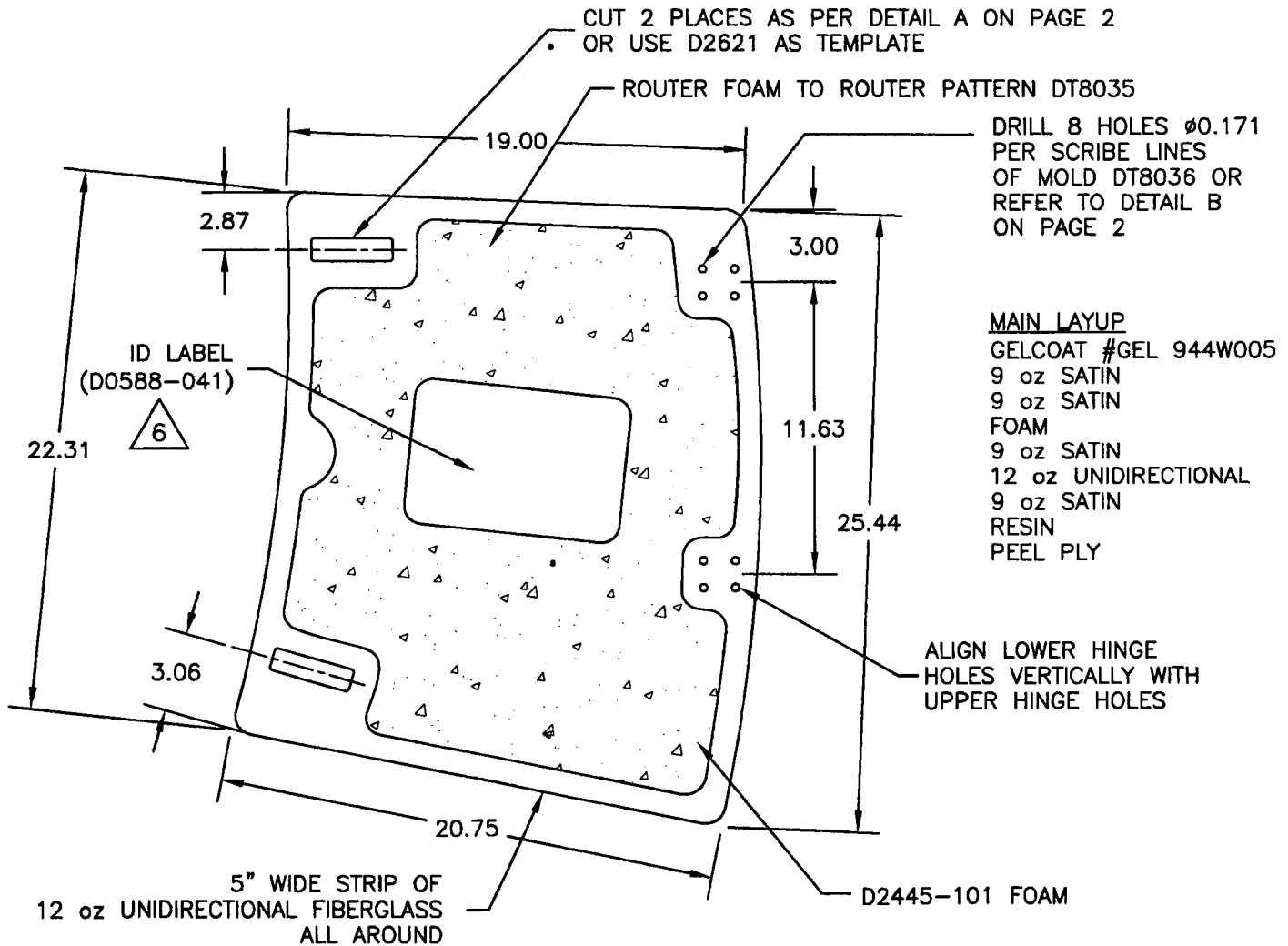
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYLCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

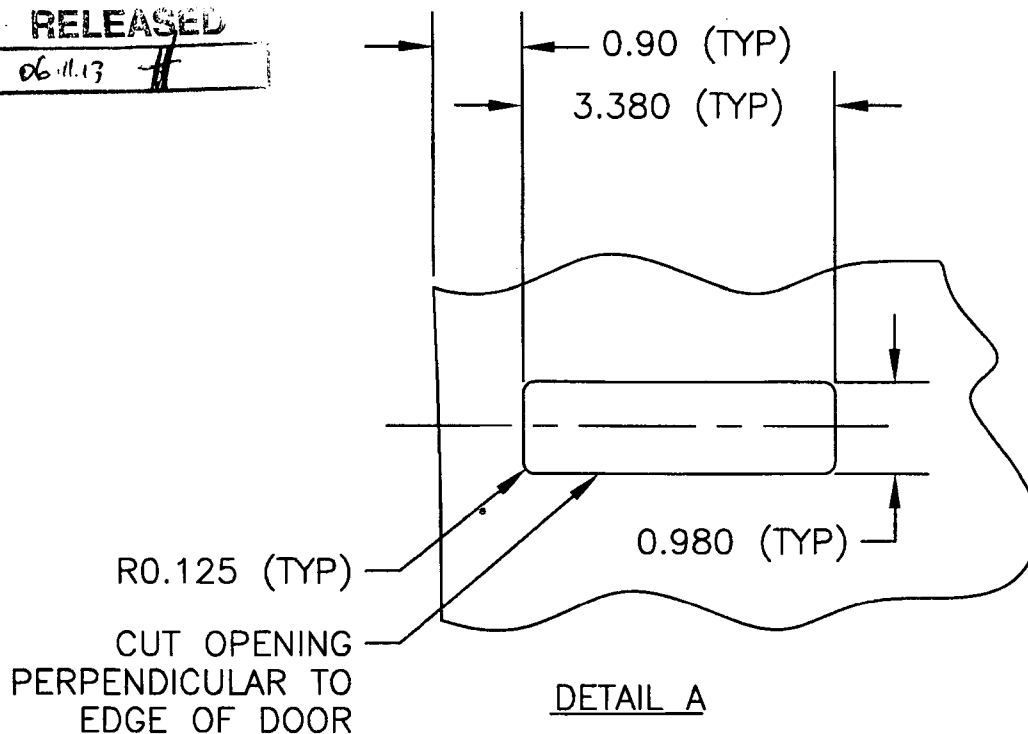
09/12/22
*W/O: 54829***Copyright © 1997 by DART AEROSPACE LTD**

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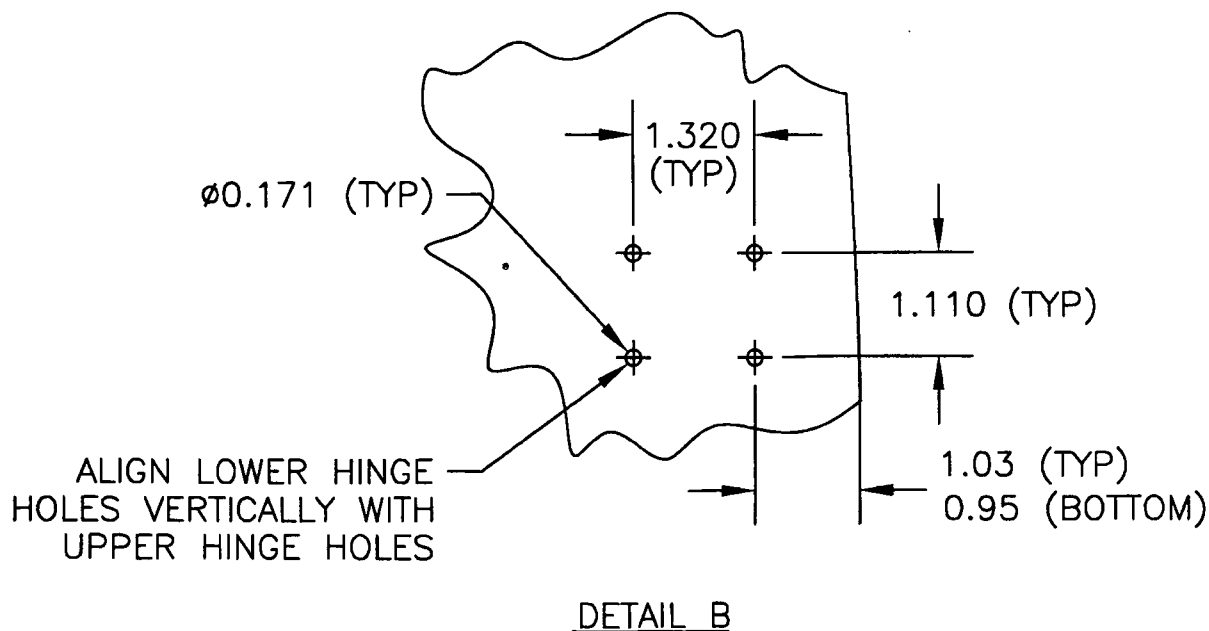


DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



54829



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REFERENCE ONLY

DART AEROSPACE LTD.

ICA-D350-588

ICA Page 33 (34 blank) of 34

52.3 WEIGHT AND BALANCE

For Kit

For ASS.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

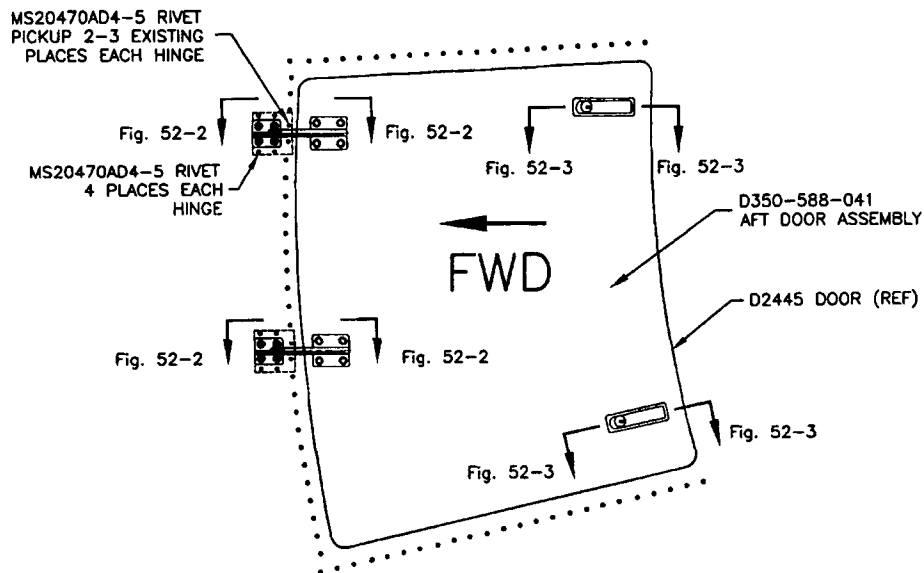
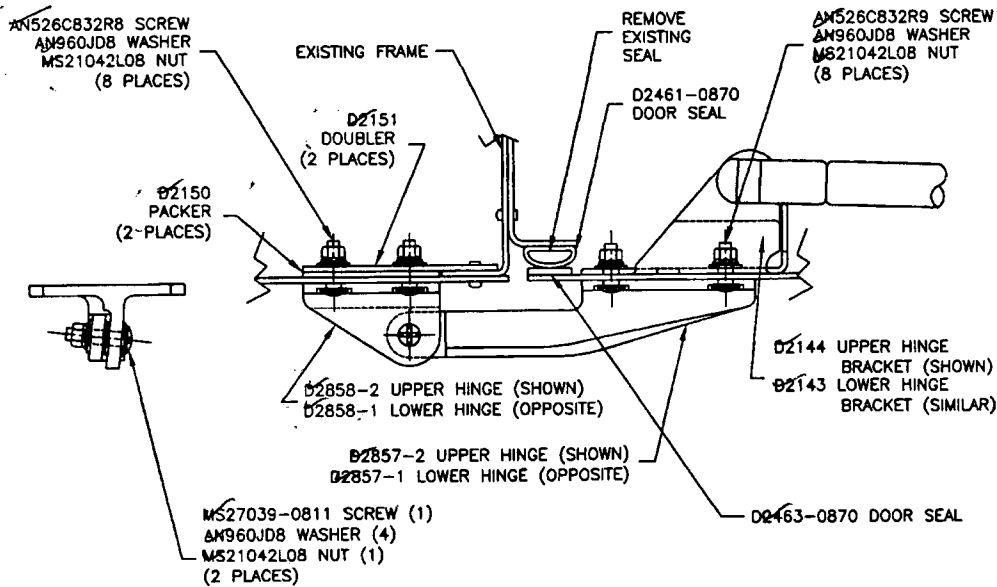
588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
16	24	AN960JD8	WASHER x8
4	4	AN960JD10	WASHER x2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET x4
10	18	MS21042L08	NUT (or MS21042-08) x6
4	4	MS21042L3	NUT (or MS21042-3) x2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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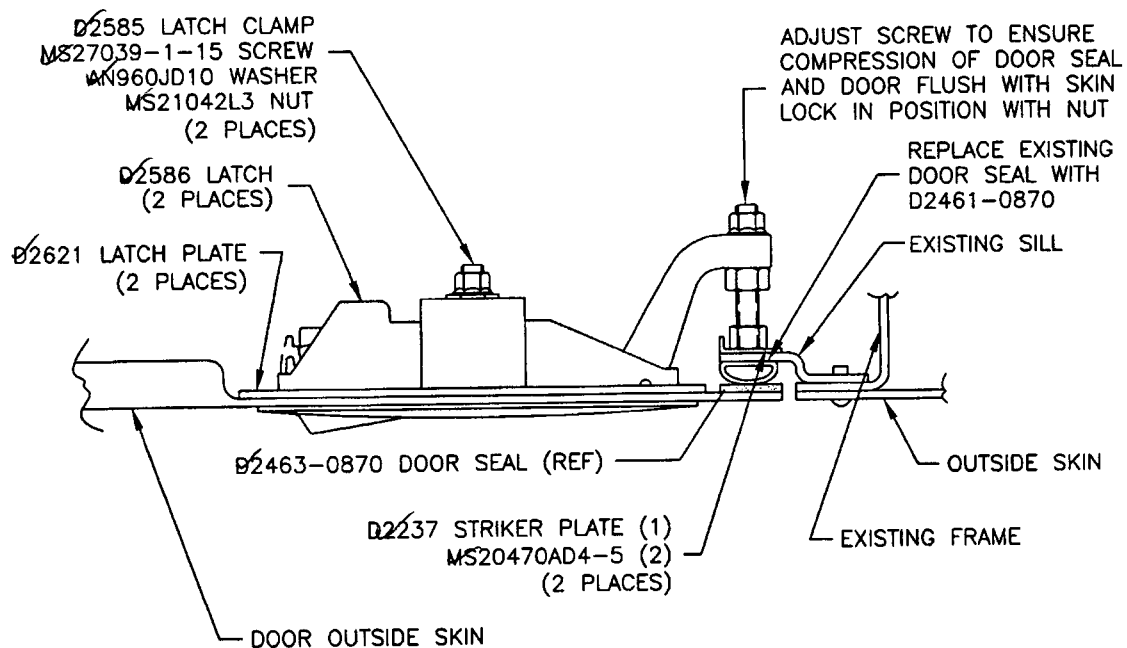
Revision: 0

Page 13 (14 blank) of 14

REFERENCE ONLY**Figure 52-1: Baggage Door Outside View****Figure 52-2: Hinge Detail**

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REFERENCE ONLY**Figure 52-3: Latch Section**

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52-00-00



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13282
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/01/2010	06/01/2010	6081	Chantal Lavoie		PO11005		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B54829 U de M : Each Drawing N° : D2445 Rév.: D Job: 43615 S 10/01/20			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department


AQ-357



Date: Mercredi, 2009-01-21 08:21:54
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : AFT BAGGAGE DOOR D2445
Numéro Job : 43615		Numéro Article : DKC134-0013
Numéro Soumission : 2017		Numéro Dessin : D2445
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2009-01-21	No. B.V. :	Révision dessin : D
Prsht Rev. : NC		Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - -	Type :	Date Dûe : 2009-01-28
Job précédente : 43614		Qté: 1 UdM: UNITE

Écrit par : 
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aérospatiale: D2445
 N° Delastek Composites: DKC134-0013
 N° de projet Delastek: DK-362

 Process Sheet Rév.: 10 Modification du planning afin d'y inclure le
 N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.:	0.020 GALLON(s)/Unit	Total :	0.020 GALLON(s)
Frekote 44NC			

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup:	0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART		

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.:	0.200 GALLON(s)/Unit	Total :	0.200 GALLON(s)
Gel Coat Blanc N° Gel 944W005			

 N° de Lot: 1-6961-1

4.0	AAC0275	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.:	0.0320 PINTÉ(s)/Unit	Total :	0.0320 PINTÉ(s)
Catalyst N° DDM-9			

 N° de Lot: 1-6118-3

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

5.0 AC0260 Acetone

Commentair Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)
Acetone

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 5-2-09 Sceau:  Temps Début: 9:00 Temps Fin: 9:15

7.0 GEL COAT. APPLICATION DE GEL COAT

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 5-2-09 Sceau:  Temps Début: 9:15 Temps Fin: 9:30

8.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B

9.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)
Feutre de drainage N° Airweave N 10

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

Stretchlon 200 poche à vide Vert

12.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-6925-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-21729-1

14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 23-1-09 Heure Début: 10:20 Heure Fin: 10:40 Sceau:

16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.359 KILOGRAMME(s)/Unit Total : 0.359 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-23335-1

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 5-2-09 Heure Début: 12:35 Heure Fin: 12:40 Sceau: 



19.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 5-2-09 Heure Début: 12:40 Heure Fin: 12:55 Sceau:  

20.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 5-2-09 Heure Début: 12:55 Heure Fin: 1:10 Sceau:  Curing début: 12:40 Curing Fin: 8:00

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

43.0 AAC0683 Dupont Primer N° 7704S

Commentaire Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)

Dupont Primer N° 7704S N° de Lot: 1-21723-1

44.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentaire Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

Dupont Activator - Reducer Chromabase N° 7775S 1-24803-3

45.0 PRIMER APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 13/02/09 Sceau:

Quantité: 1 Date: 13/01/10 Sceau:

Quantité: Date: Sceau:

Quantité: Date: Sceau:

46.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.

Date: 14-01-10 Heure Début: 10:55 Heure Fin: 11:05 Sceau:

47.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 14/1/10 Sceau:

Quantité: Date: Sceau:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0042 PINTE(s)/Unit Total : 0.0042 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

22.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6938-1

23.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 2-2-09 Heure Début: 2:10 Heure Fin: 2:15 Sceau:

24.0 AAC0452 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F

N° de Lot: 1-6724-1

25.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) 43527

26.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 6-2-09 Heure Début: 9:20 Heure Fin: 9:35 Sceau:

Client: DART Dart Aerospace Ltd.
Numéro Job: 43615

Nom Dessin: AFT BAGGAGE DOOR D2445
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE





Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 6-2-09 Heure Début: 9:35 Heure Fin: 9:45 Sceau:  

Curing Début: 9:20 Curing Fin: 11:35

28.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

29.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-23335-1

30.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 9-2-09 Heure Début: 10:20 Heure Fin: 10:25 Sceau: 

31.0 LAMINAGE. LAMINAGE PIÈCE DART
















Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: AFT BAGGAGE DOOR D2445	
Numéro Job: 43615		Numéro Article: DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	allant dans le coin droit en bas se superposent		
	Faire le laminage du dernier pli de 9.7 oz.		
	Date: <u>9-2-09</u> Heure Début: <u>10:25</u> Heure Fin: <u>10:55</u> Sceau:  		
32.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs FAIRE LA POCHE À VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à délaminer.			
2- Film perforé P-3.			
3- Feutre de drainage			
4- Sac à vide Stretchlon 200.			
Laisser sécher pendant 4 heures minimum.			
Date: <u>9-2-09</u> Heure Début: <u>10:55</u> Heure Fin: <u>11:05</u> Sceau:  			
Curing Début: <u>10:25</u> Curing Fin: <u>4:20</u>			
33.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs DÉMOULAGE PIÈCE DART			
Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".			
Date: <u>10-2-09</u> Heure Début: <u>8:15</u> Heure Fin: <u>8:20</u> Sceau: 			
34.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs TRIMAGE COMPOSITES DART			
À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de penture selon le dessin N° D2445.			
Date: <u>10-2-09</u> Heure Début: <u>1:30</u> Heure Fin: <u>2:00</u> Sceau: 			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 43615

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AAC0062 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Label N° D0588-041

Lot: 1-26247-1

36.0 AAC0444 Surface Veil

Commentair Qty.: 0.07 VERGE CAR(s)/Unit Total: 0.07 VERGE CAR(s)

Surface Veil

37.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)

Résine Mia-Poxy

38.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 PINTE(s)/Unit Total: 0.007 PINTE(s)

Durcisseur 95 Pour Résine Mia-Poxy

39.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

1- Surface Veil

2- Label

3- Surface Veil

Laisser scher pendant 4 heures.

Date: 12-01-10 Heure Début: _____ Heure Fin: _____ Sceau: _____



40.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.025 UNITE(s)/Unit Total: 0.025 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6893-1

41.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

42.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 10-2-09 Heure Début: 4:00 Heure Fin: 4:15 Sceau: _____

